Work Order ID 96186

January-23-13 1:13:25 PM

96186

Item ID: D3195-043 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket Assembly

Start Date: 1/21/13 **Start Qty:** 4.00 *4*

Required Date: 2/08/13 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** [illegible] **Date:** 1/30/24 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3195	Rev B								
100		0.00							
100	BAND SAW		F.K		13/02/04	4	0		
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blanks: (1.250" x 1.500") x 3.60" long								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1		F.K		13/02/04	4	0		
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-32-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120			F.K		13/02/04	4	0		
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Item ID: D3195-043 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket Assembly

Start Date: 1/21/13 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 2/08/13 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check	0.00	D.A 13/02/05			4	0		DAS 08 2-89
	Memo	0.00							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				4	[illegible] 13-2-6		
	Memo	0.00							
150 *150* Powdercoat Powder Coating	Grey Sandtex (Ref 4.3.5.6) per QSI005 4.3 M188466	0.00				4	0 DL 13-2-11		
	Memo	0.00							

START TIME: 9:30 OVEN TEMPERATURE: 200°
FINISH TIME: 10:00

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

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- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Item ID: D3195-043 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket Assembly

Start Date: 1/21/13 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 2/08/13 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish	0.00 SmB				4			
	Memo	0.00 13.211							
170 *170* Small Fab Small Fab	Small Fab	0.00				4			FF 13-02-20
	Memo 1-Lightly Sand bonding surface2-Bond D3195-7 into D3195-13as per Dwg D3195A/RContact Cement 7124297	0.00							
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00 SmB				4			
	Memo	0.00 13.220							

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

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- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
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Material										
Setup										
Other										
Process										
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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Item ID: D3195-043 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket Assembly

Start Date: 1/21/13 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 2/08/13 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location SL 2/6/13	0.00				4X			SD 13-2-20
190									
Packaging	**Memo**	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	**Memo**	0.00							MLJ 13-02-21
Quality Control									

RL 13-02-21

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
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- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

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- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

January-23-13 1:13:25 PM

1

Work Order ID: 96186

Parent Item: D3195-043 **Start Date:** 1/21/13 **Required Date:** 2/08/13

Parent Item Name: Bracket Assembly **Start Qty:** 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-7 Pad		Manufactured	No			100	Each	17.0000	1	4	FF 13-02-20		
				Location		**Loc Qty**		**Loc Code**					
				GA		17							
					73040	1							
					83705	16				4			
M6061T6B1.500X01.250 6061-T6 Bar 1.50 x 1.25		Purchased	No			170	f	9.1688	0.3	**1.263158**			
				Location		**Loc Qty**		**Loc Code**					
				MAT003		9.1688419							
					123649	9.1688419							
				124443						1.263	Fk 13/02/04		

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

- ☐ Bending
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- ☐ Outside Dimensions
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- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

DART AEROSPACE LTD	Work Order:	96184
Description: Bracket	Part Number:	D3195-3
Inspection Dwg: D3195 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

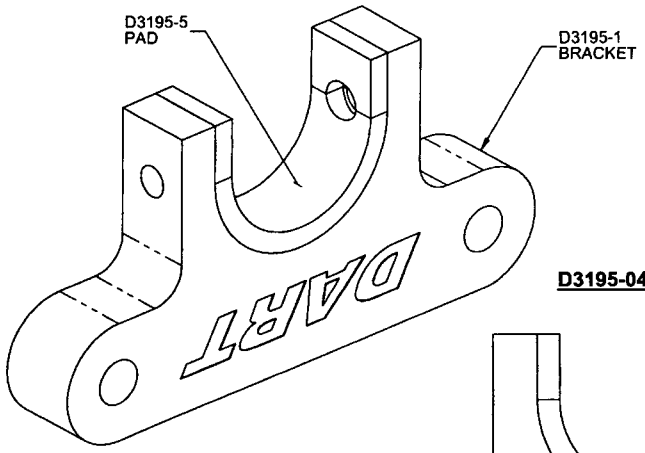
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.433	✓		FK-04	Vern.
1.265	+/-0.010	1.262	✓		"	"
R0.37	+/-0.030	.375	✓		"	"
Ø0.277	+0.005/-0.001	.277	✓		"	"
2.677	+/-0.005	2.677	✓		"	"
0.242	+/-0.010	.243	✓		"	"
0.377	+/-0.010	.378	✓		"	"
0.500	+/-0.010	.500	✓		"	"
R0.188	+/-0.010	.188	✓		"	"
0.250	+/-0.010	.250	✓		"	"
0.882	+/-0.010	.882	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
0.500	+/-0.010	.500	✓		"	"
Ø0.191	+0.005/-0.001	.191	✓		"	"
1.000	+/-0.010	1.001	✓		"	"

Measured by:	FK
Date:	13/02/04

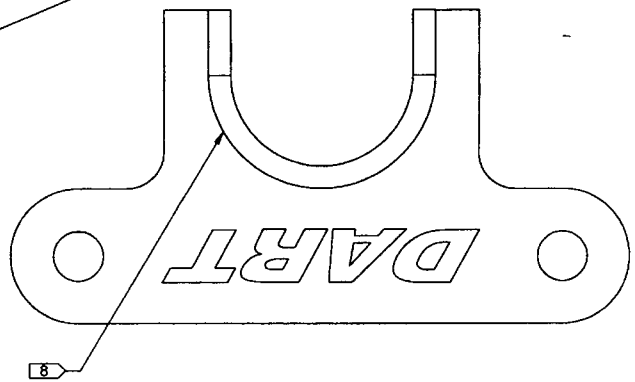
Audited by:	DAS 08 9-89
Date:	13/02/05

Preliminary Approval:	
Date:	

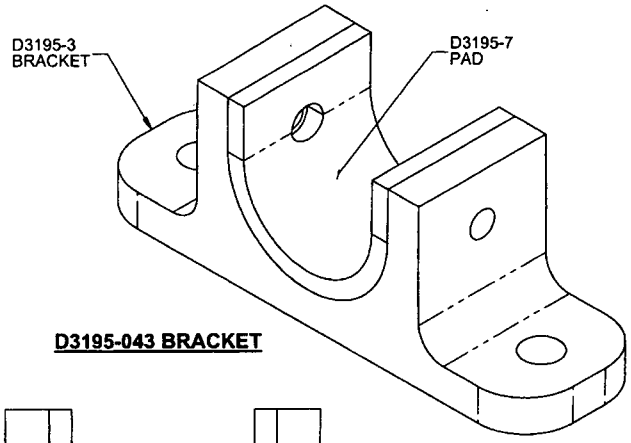
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	
C	12.05.14	Dwg Rev updated	KJ	



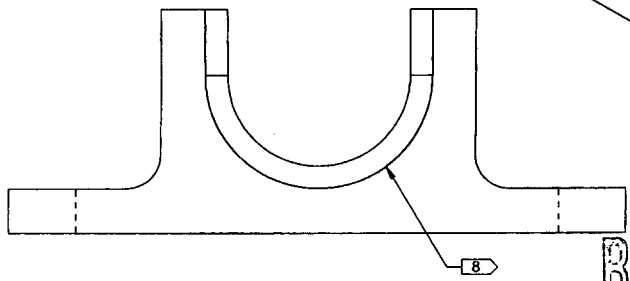
D3195-041 BRACKET



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3195-041	BRACKET
1	1	D3195-1	BRACKET
2	1	D3195-5	PAD



D3195-043 BRACKET



ITEM	QTY -043	P/N	DESCRIPTION
	X	D3195-043	BRACKET
1	1	D3195-3	BRACKET
2	1	D3195-7	PAD

Q484
RB-01-24

RELEASED
2012-04-30

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3195-04X" AND BATCH NUMBER "BXXXXX" PER QSI044 METHOD 6.1
7) WEIGHT: D3195-041: 0.15 lbs
D3195-043: 0.14 lbs
8) BOND PAD TO BRACKET USING 3M SCOTCH-WELD HIGH PERFORMANCE 1300/1300L (OR EQUIVALENT) (B)

REV.	DESCRIPTION	BY	DATE
B	- UPDATED DRAWING FORMAT. - ADDED NOTE 8, SHEET 1. - D3195-5 & D3195-7 DIMENSIONS EXTENSIVELY REVISED (B6-3, C3-3) - REF: PAR11-130	RP	12.04.13
A	NEW ISSUE	CP	03.06.23

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RP	
CHECKED	A.P.	DRAWING NO. D3195 — REV. B — SHEET 1 OF 3
MFG. APPR.		
APPROVED		TITLE: BRACKET — SCALE: NTS
DE APPR.		
DATE	12.04.13	

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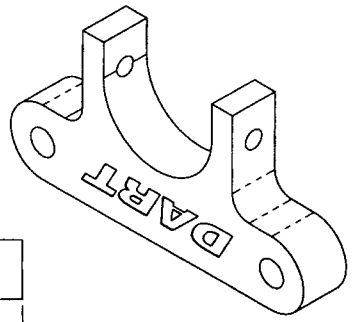
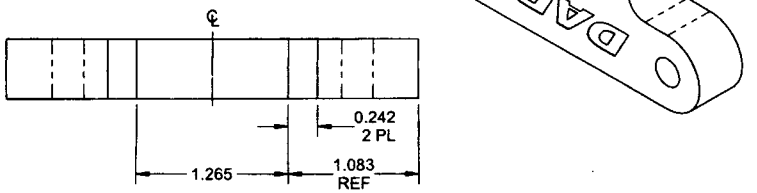
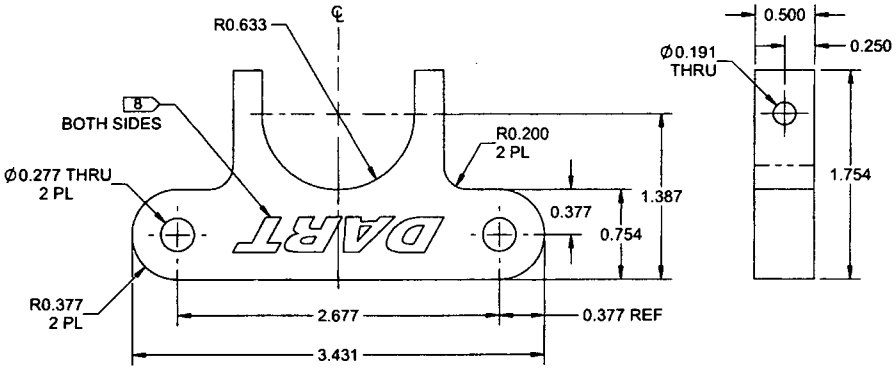
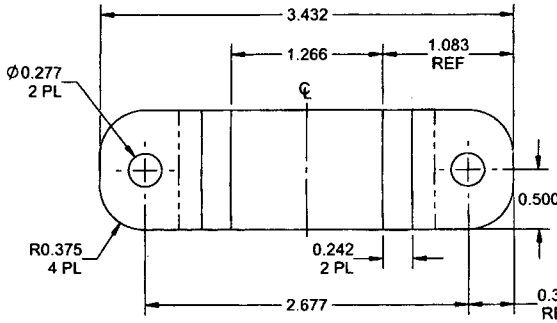
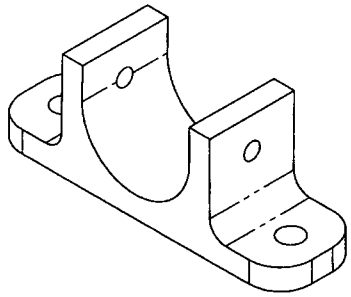


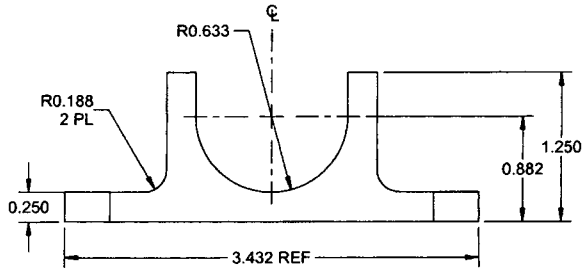


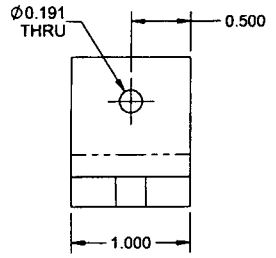


D3195-1 BRACKET









D3195-3 BRACKET

Released
2012-04-30

96186

NOTES:
1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR
ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3195-1 0.15 lbs
D3195-3 0.14 lbs
8) ENGRAVE DART LOGO AS SHOWN USING 0.28 HIGH X 0.005 DEEP LETTERING (TYPICAL BOTH SIDES)

DESIGN	RP	**DART AEROSPACE LTD**
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P	DRAWING NO. D3195 REV. B
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE	12.04.13	

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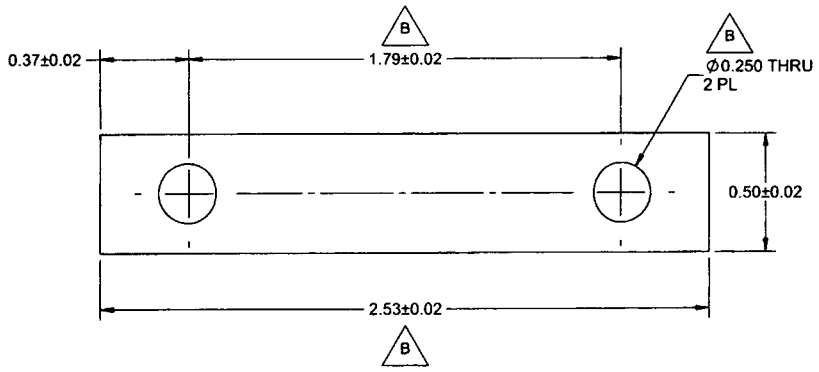
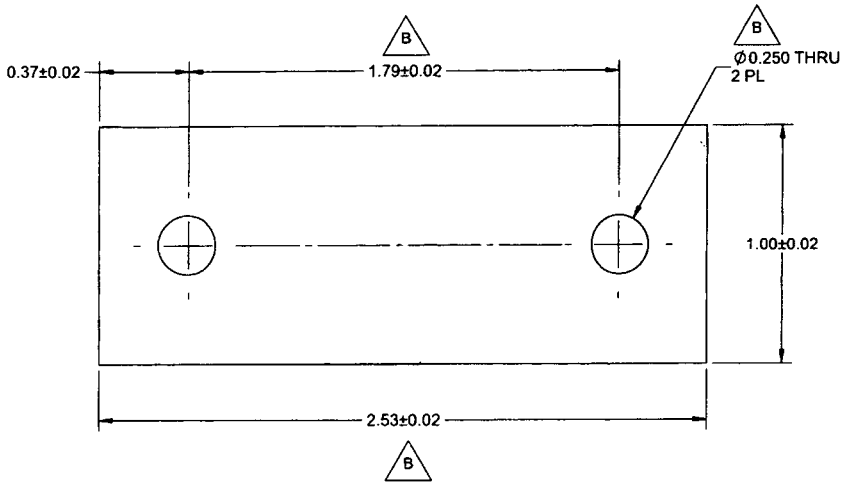


D3195-5 PAD



D3195-7 PAD

RELEASED
2012 -04- 30

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NOTES:
1) MATERIAL: BLACK NEOPRENE SHEET, 1/8" THICK, 60 DUROMETER
(REF DART SPEC M-NEO60-S.125)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: LESS THAN 0.01 lbs

DESIGN	RP	**DART AEROSPACE LTD**
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P.	DRAWING NO. D3195 — REV. B
MFG. APPR.		SHEET 3 OF 3
APPROVED		TITLE: BRACKET — SCALE: NTS
DE APPR.		
DATE	12.04.13	

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